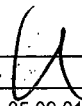



Date: Thursday, 16/08/2007 3:11:12 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L AFT X-TUBE
Job Number	: 34043		
Estimate Number	: 10973		
P.O. Number	: N/A	Part Number	: D206667203
This Issue	: 16/08/2007 S.O. No. : N/A	Drawing Number	: D206-667-243 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/08/2007 Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 34042	Material	: N/A
Written By	: 	Due Date	: 05/09/2007
Checked & Approved By	: 	Qty:	1 Um: Each
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

DC

DOCUMENT CONTROL



KS 07-08 27

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

6 07/10/04

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B99114

Check OD = 2.500"; ID = 1.800"

SF 07/08/17

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

SF 07/08/17

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SF 07/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/17	3.0	Left SS too long Dim: 2.547 suppose 2.437			S.P 07/08/17			
		R.C operator error origin was bad on the first side.						

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

28 07/08/21

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

28 07/08/21

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 07-09-24

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

JB 7-9-24

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 21/08/24

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 1-9-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT EL 7-9-25

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

1409.250

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

PTO

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

JD 7-9-26

EL/SR
7-9-25

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-9-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070925	13.1	height is slightly low, but within QS1042 tolerance, MRB	<i>[Signature]</i> QS1042	Drill cuffs @ .675"	EZ 7-9-05	E 7/6/05	<i>[Signature]</i> QS1042	<i>[Signature]</i> 7-9-05

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/26

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/26

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4701

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 207/09/27 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

02/9/27 (1)

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

En 07/09/27

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

~~1-Mask Threaded holes~~ N/A

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

m 07 09 29 (1)

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 07-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 32777

ml 07 09 30

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 32512x1 / 33422x1

RT 07 10 -03

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 105057

RT 07 10 -03

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07 10 -03

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip 34293

ml 07 09 30

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support 828389

ml 07 09 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 MS2192022 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105066

ml 07 09 30

29.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml 07 09 30

30.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 02/06/03

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0 AN534A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M105408

6

33.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M1048/2

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 27/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:11:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 34043

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-10A Bolt M102020

35.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-32A Bolt M104427

36.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M104156

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev: C

39.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12 07/10/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26 -H**UNDER REVIEW**
06.08.10 RH
re-draw detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

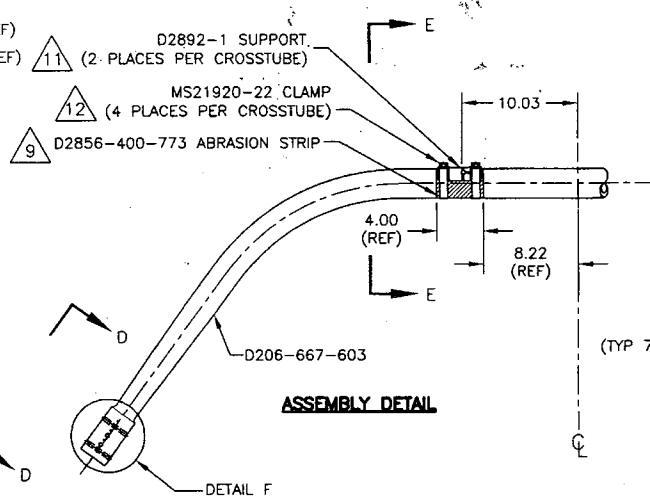
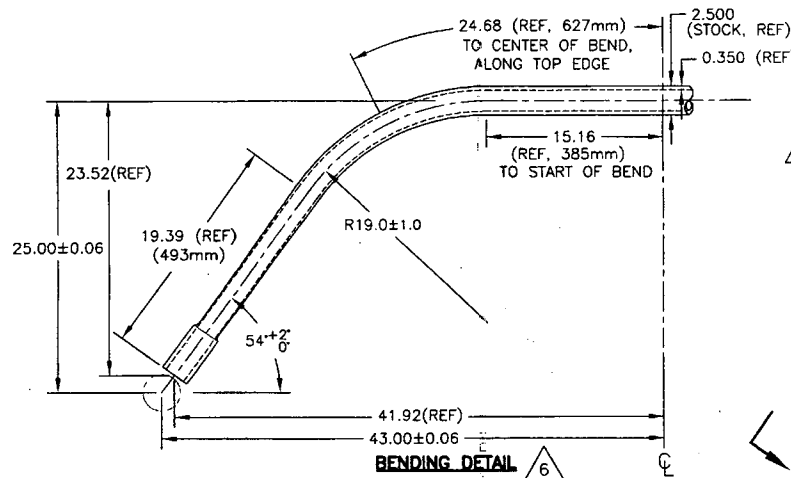
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

4/8 34013

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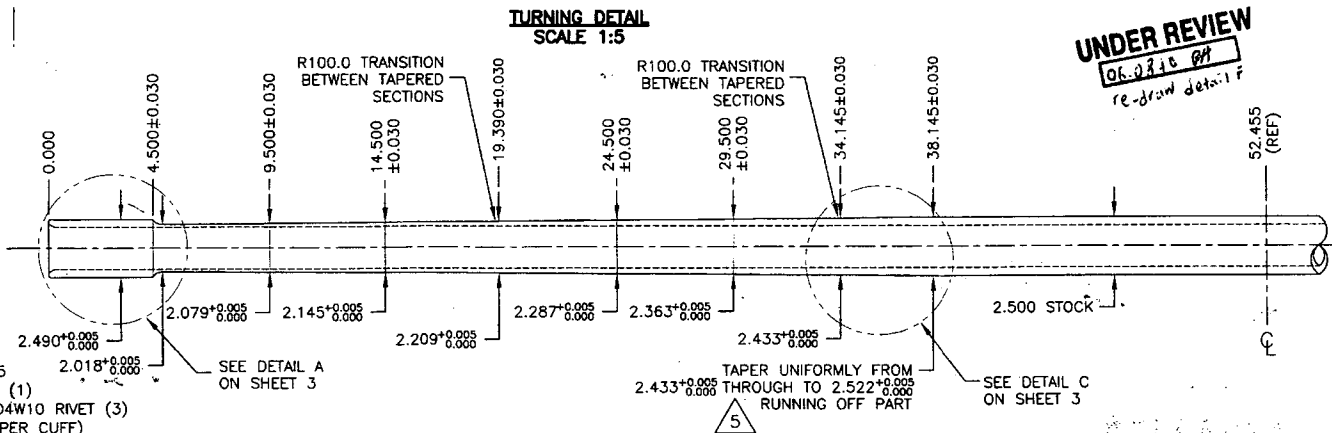
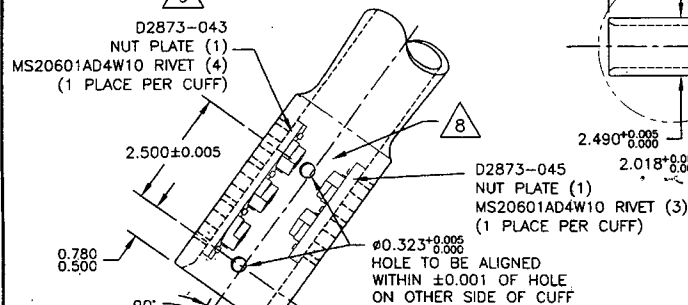
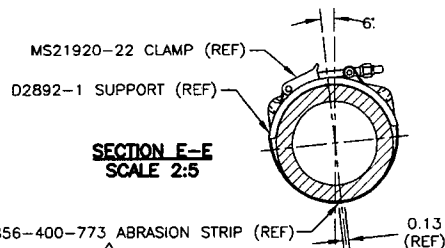
B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

UNDER REVIEW
06.02.16 PH
re-draw detail F

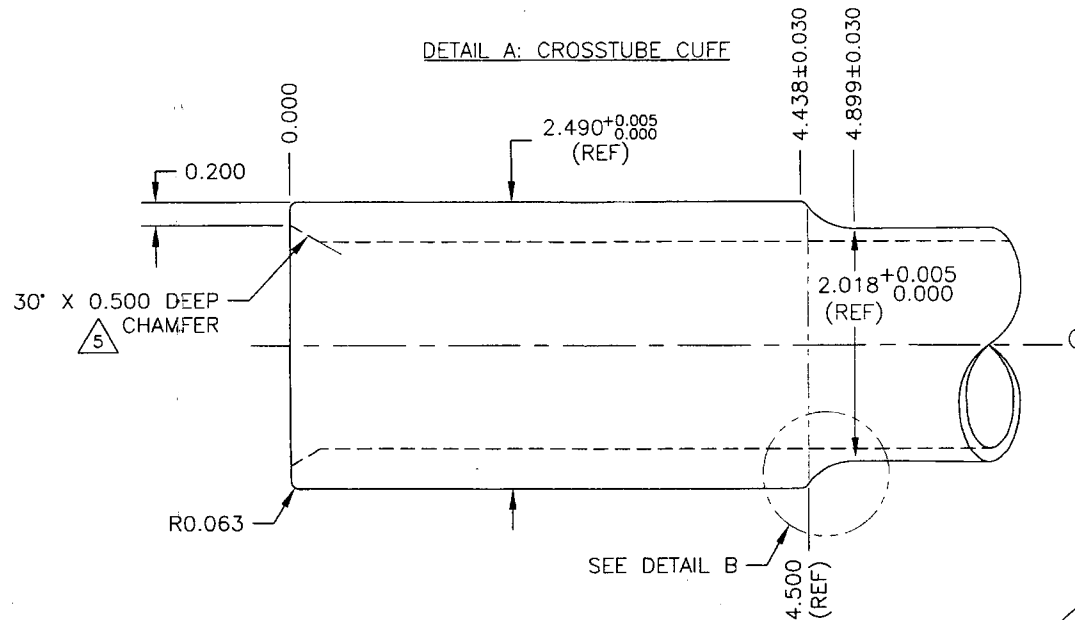


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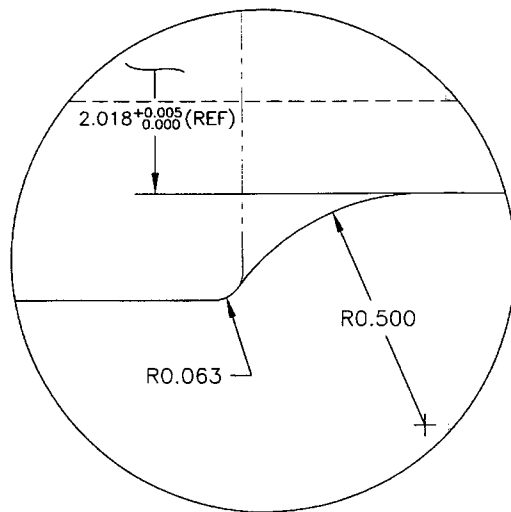
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DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-243
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	REV. B SHEET 2 OF 3 SCALE 1:10

DETAIL A: CROSSTUBE CUFF

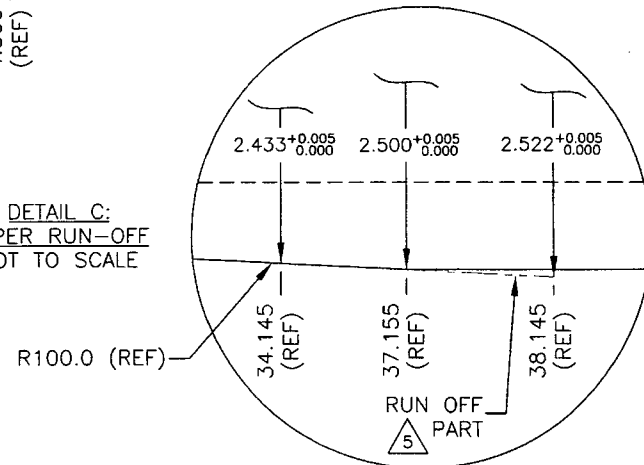


UNDER REVIEW
06.03.10 PH
re-drawn detail



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1	

DART AEROSPACE LTD	Work Order: 34043
Description: Crosstube Assembly	Part Number: D206-667-243
Inspection Dwg: D206-667-243 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.493				
	2.018	+0.005/-0.000	2.021	2.019			-0.002
	2.079	+0.005/-0.000	2.081	2.079			
	2.145	+0.005/-0.000	2.148	2.146			
	2.209	+0.005/-0.000	2.211	2.209			
	2.287	+0.005/-0.000	2.290	2.288			
	2.363	+0.005/-0.000	2.368	2.364			
	2.433	+0.005/-0.000	2.436	2.434			
	0.200	+/-0.010	0.202				
	0.500 x 30°	+/-0.010	0.500				
	R0.063	+/-0.010	0.063				
	R0.500	+/-0.010	0.500				
	4.438	+/-0.030	4.547				+0.109
	104.91	+/-0.020	104.91				
	2.490	+0.005/-0.000	2.493				
SIDE B	2.018	+0.005/-0.000	2.021				
	2.079	+0.005/-0.000	2.081				
	2.145	+0.005/-0.000	2.148				
	2.209	+0.005/-0.000	2.211				
	2.287	+0.005/-0.000	2.290				
	2.363	+0.005/-0.000	2.366				
	2.433	+0.005/-0.000	2.436				
	0.200	+/-0.010	0.200				
	0.500 x 30°	+/-0.010	0.500				
	R0.063	+/-0.010	0.063				
	R0.500	+/-0.010	0.500				
	4.438	+/-0.030	4.444				
	104.91	+/-0.020	104.91				
	2.490	+0.005/-0.000	2.493				
	2.018	+0.005/-0.000	2.021				

Measured by: JF	Audited by: JF	Prototype Approval:	N/A
Date: 07/08/17	Date: 07-09-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

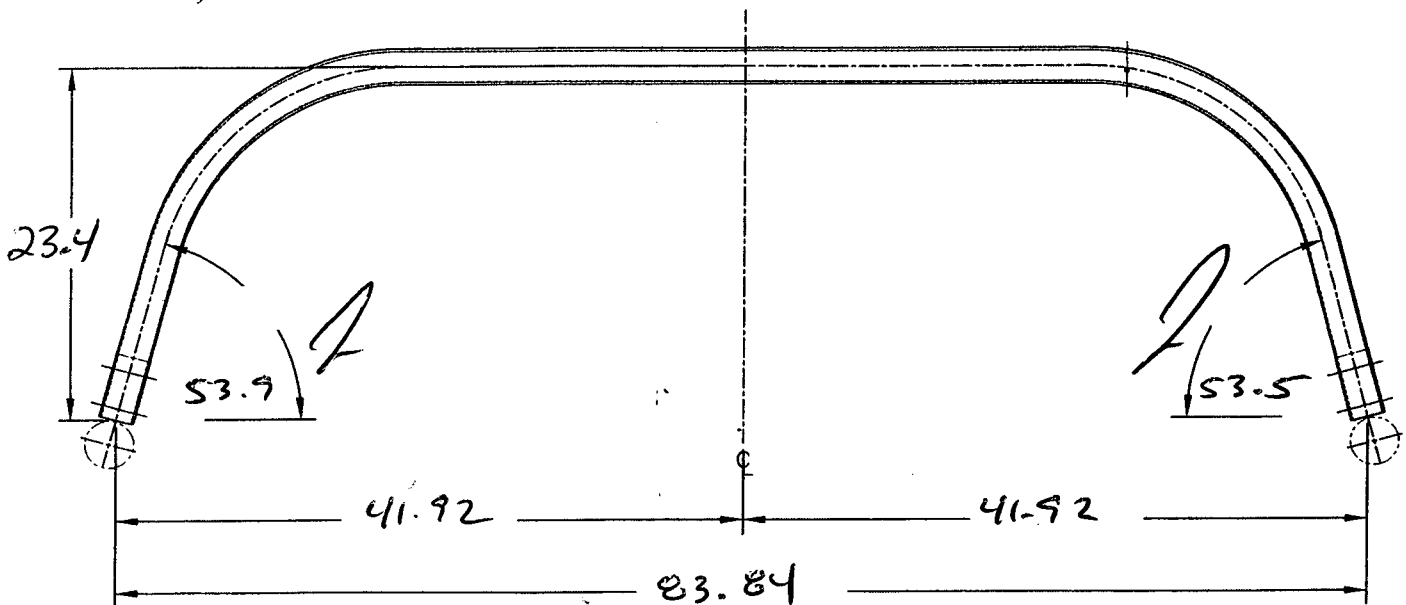
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34043
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
- Tube is even.
- drill eff holes @ .675

QC15 Inspection	<i>[Signature]</i> 05/04/12
Date	07/02/25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Bill Beckett

From: Mike Petsche [mpetsche@dartaero.com]
Sent: September 20, 2007 8:17 AM
To: 'Beckett, Bill'
Subject: FW: NCR D205-667-243

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: September 19, 2007 9:43 PM
To: 'David Shepherd'
Cc: 'Petsche, Mike'
Subject: NCR D205-667-243

David,

Qty(3) D206-667-243 crosstubes. They are all from difference dates and have been waiting for disposition.

B/N 34043. Overall length is to dwg. One cuff is 4.547" long instead of 4.438" (+0.109"). The OD measurements are all within tolerance.

B/N 32142. Overall length is to dwg. One cuff is 4.386" long instead of 4.438" (-0.052"). The OD measurements are all within tolerance.

B/N 34051. Overall length is to dwg. One cuff is 4.270" long instead of 4.438" (-0.168"). The OD measurements are all between 0.007" and 0.008" above maximum tolerance (on affected side only). The shifted taper would only increase the OD by 0.002", so the tool must have been zero'd wrong in both directions. The tube is obviously strong enough, but would be stiffer on one side. Perhaps they could run the program again, then polish out the transition.

Cosmetically, from the top of the saddle to the top of the cuff is 0.68" nominally, which would drop to 0.512" for the worst case cuff.

In my opinion, the first two are acceptable, the last one would be acceptable if re-machined within tolerance.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.487 / Virus Database: 269.13.22/1015 - Release Date: 18/09/2007 11:53 AM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.487 / Virus Database: 269.13.22/1015 - Release Date: 18/09/2007 11:53 AM



LIQUID PENETRANT TEST REPORT

P - 1178 1

CLIENT	DART AEROSPACE	DATE	SEP 27 2007	PAGE	1	OF	2
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 07 1178	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/VO No.					
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	206L AFT X TUBES, 212/205 HIGH AFT X TUBE						
ITEM(S) EXAMINED	JOB #'S 31038, 32142, 34043, 34051, 34482, 32681.						

JOB DESCRIPTION	PROCEDURE No.	LT-0002	REV./DATE	TECHNIQUE No.	LT-TECH2	REV./DATE
PART No.	D206667203/D212664201		MATERIAL	7075 ALODINED ALUM.		THICKNESS
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE					

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT ZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL SEP 18 07	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input checked="" type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL SURFACE ON:
206L AFT X TUBES JOB#S 31038, 32142,
34043, 34051, 34482.
212 HIGH AFT X TUBE JOB# 32681.

RESULTS: NO INDICATON OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD.

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		SIGNATURE	DTR # E 13167
TECHNICIAN (SIGNATURE):			REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT		NAME INITIALS
	1 ST TECHNICIAN	2 ND TECHNICIAN	
CGSB LEVEL	2	CGSB LEVEL	
CGSB REG. No	6156	CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY